



EXPRESS COMPOSITES, Inc.



PRODUCT INFORMATION

Polyester & VinylEster Resins:

Mix and measure accurately according to the chart below. Use an MEKP dispenser, measuring cup, or for quantities lower than 3cc, use a syringe. The % listed is the minimum and must not be decreased to give more working time. Since these products are mass exotherm sensitive, mix small fresh batches and keep a wet edge. As soon as you have mixed your batch pour mixture onto the reinforcement as a thin film will give you more working time.

catalyst ↓	RESIN		
	Cup (8 oz.)	Pint (16 oz.)	Quart (32 oz.)
1%	2.5 cc/ml	5 cc/ml	10 cc/ml
1 1/4%	3 cc/ml	6cc/ml	12.5 cc/ml
1 1/2%	4 cc/ml	8cc/ml	15 cc/ml
2%	5 cc/ml	10cc/ml	20 cc/ml

COMMON REQUIREMENTS



Polyester: 1 - 1/4%

VinylEster: 1 1/2%

OUR Gelcoats: 2%

Duratec Products: 2%



Wetting out Fiberglass:

Chopped strand mat requires the use of a finned laminating roller to eliminate air voids. These voids will appear as a white spot. The same technique applies for a woven cloth, only you use a soft squeegee to eliminate both air and excess resin, producing a lean laminate. If the voids become apparent after the laminate has set-up, proper procedure is to grind or sand out the bubble and do a small fiberglass repair over the affected area.

IMPORTANT!:

In cold months, resin must be warmed to room temperature before using for adequate curing. Resin, part, and shop temperature should be at least 65 degrees Fahrenheit thru the cure cycle which could be as long as 12 hours. In hot months, do not go below minimum, just work faster! We also carry an MCP hardener that extends geltimes by about double.

FOR A TACK-FREE FINISH ON GEL COAT OR RESIN, and you are sure it is the FINAL coat, USE 3 oz. Surfacing agent per gallon.



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